

Date: Monday, 12/05/2008 10:02:10 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	OUTER FWD SADDLE
<b>Job Number</b> :	39196		
<b>Estimate Number</b> :	11076		
<b>P.O. Number</b> :		<b>Part Number</b> :	D5951
<b>This Issue</b> :	12/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D5951 REV.B
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38365	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUL 08.5.12</u>	<b>Due Date</b> :	05/06/2008
<b>Comment</b> :	Est Rev:E Re-Format 05-11-29 JLM Est Rev:E Re-Format 05-11-29 JLM	<b>Qty:</b>	8 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101013	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: B3886

DIP 08/05/25

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5951, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

DIP 08/05/25 / 85 08/05/27

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

DIP 08/05/25 / 85 08/05/27

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SD 08/05/28

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

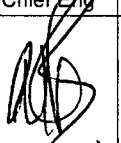



Chemical Conversion Coat as per QSI 005 4.1

M. P. / R. 08/05/28

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5951 PAR #: N/A Fault Category: Prod / Machine Part NCR: (Yes) No DQA: D Date: 08/05/27  
 QA: N/C Closed: D Date: 08/05/30

NCR: 39196		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/27	2.0	Machine malfunction lost IS Y position. Top of saddle was off center.  R.C. Machine Malfunction	 08/05/27	Scrap and destroy  Replne Qty (40)  B# 38696	S.F 08/05/27	 08/05/27	 08/05/27	 08/05/27
		had already made two complete parts already.						

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:02:10 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 39196

Part Number: D5951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M107892



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:55

OVEN TEMPERATURE:

320°

FINISH TIME:

12:25

FL

08/05/28

(8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-10

08/05/28

(8X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

C-208/05/28

(8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/28

Job Completion



M-10 08-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_ 6

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	3096
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b>	D5951
<b>Inspection Dwg:</b> D5951		<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.437	0.444		0.444	.443	.443	.443		
B	1.745	1.755		1.748	1.748	1.748	1.750		
C	5.245	5.255		5.247	5.246	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.248	5.248	5.250		
F	4.745	4.755		4.751	4.748	4.750	4.750		
G	0.315	0.322		0.322	.319	.320	.320		
H	1.522	1.532		1.527	1.525	1.525	1.525		
I	3.048	3.058		3.054	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.500		
K	0.315	0.322		0.322	.321	.321	.321		
L	0.495	0.505		0.500	.501	.502	.500		
M	0.490	0.510		0.499	.500	.500	.501		
N	1.615	1.635		1.623	1.625	1.625	1.625		
O	7.990	8.010		7.996	7.997	8.001	8.000		
P	2.240	2.260		2.252	2.250	2.250	2.250		
Q	0.307	0.312		.311	.311	.311	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		0.500	.498	.500	.500		
T	1.375	1.395		1.385	1.385	1.385	1.385		
U	2.000	2.020		2.0045	2.003	2.002	2.002		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DT  
Date: 08/05/25 / 08/05/27

Audited by: SD  
Date: 08/05/25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39196
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5A	6A	7A	8A		
A	0.437	0.444		.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.748		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.321	.321	.321	.321		
H	1.522	1.532		1.528	1.528	1.528	1.528		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.321	.321	.321	.321		
L	0.495	0.505		.500	.501	.501	.501		
M	0.490	0.510		.499	.499	.499	.500		
N	1.615	1.635		1.625	1.625	1.625	1.625		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.385	1.385	1.385	1.385		
U	2.000	2.020		2.001	2.003	2.002	2.002		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: S.F.
Date: 08/05/27

Audited by: SA
Date: 08/05/28

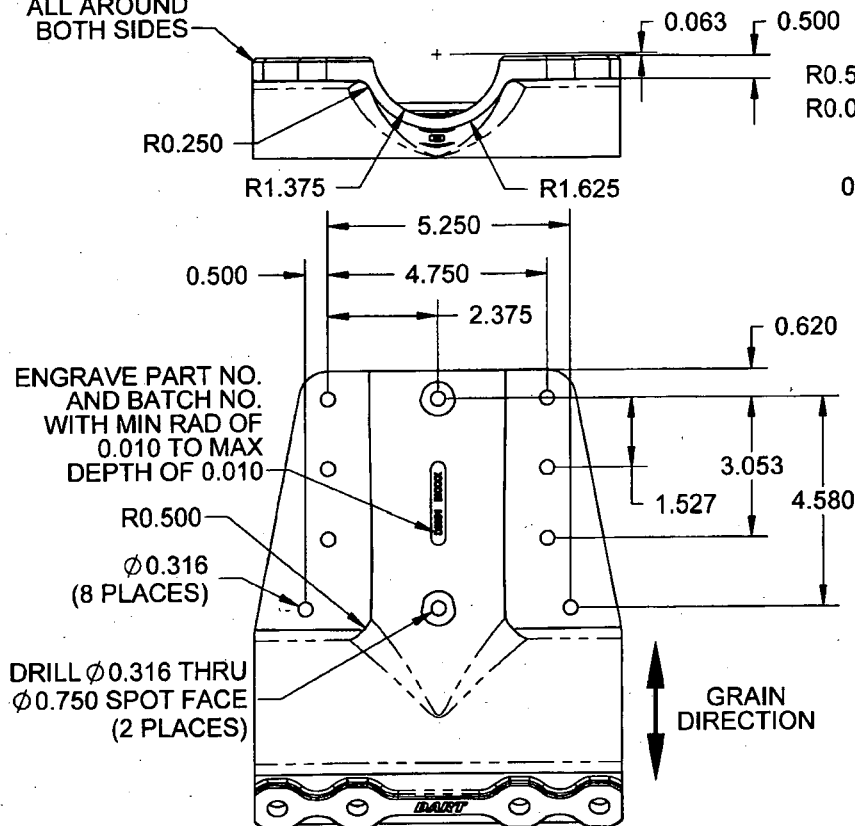
Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5951</b>
DATE <b>06.11.07</b>	TITLE <b>OUTER FWD SADDLE</b>	REV. B SHEET 1 OF 1 SCALE 1:4
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>
<b>B</b>	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;

CHAMFER  
0.075 X 45°  
ALL AROUND  
BOTH SIDES

RELEASED  
06.11.28



DETAIL B  
SCALE 1:1

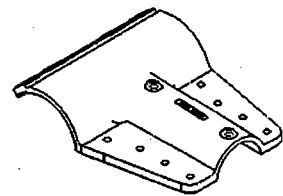
VIEW A-A

**D5951 OUTER FWD SADDLE** 39196

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
SCALE 1:8



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